

5/12

DART AEROSPACE LTD	Work Order:	22679
Description: Hub Sleeve	Part Number:	D3233-5
Dwg: D3233 Rev. B	Qty:	5
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.03.15	4
2	CL	Turn as per Dwg D3233 Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) Identify for D3233-5			
		Batch: M17015	CPL	05.03.31	4
3	QC2	Inspect parts as they come off the machine Identify as D3233-5	ER	05.03.31	5
4	CM	Mill as per Dwg D3233	ER	05.03.31	5
5	QC8	Second check	HA	05.04.01	5
6	CM	Deburr	ER	05.04.01	5
7	QC5	Inspect work to Step 6	HA	05.04.01	5
8	ST	Identify and Stock	CPL	05.04.01	5
9	AC	Cost / part 29.44	Syc	05.04.06	5
10	DC	Close W/O 29.44 Inspect Level 21	HA	05.04.12	5

Rev	Date	Change	Revised By	Approved
A	05.03.14	New issue	KJ/JLM	HA

RELEASED
05.03.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

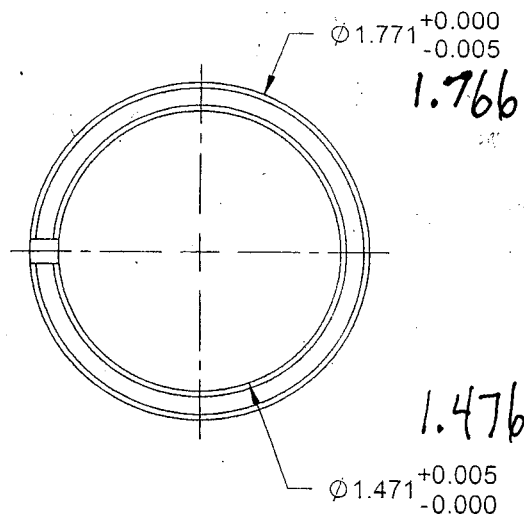
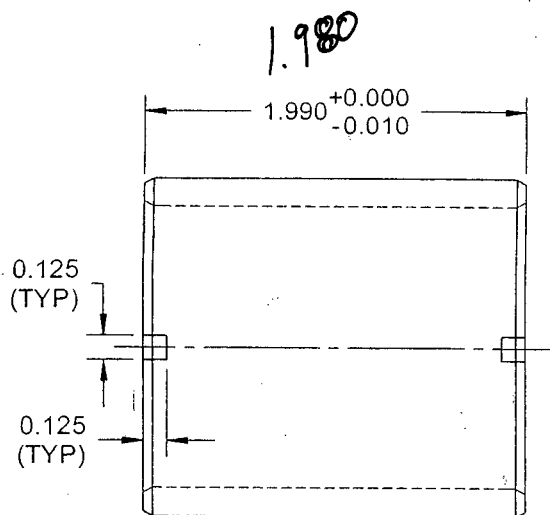
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

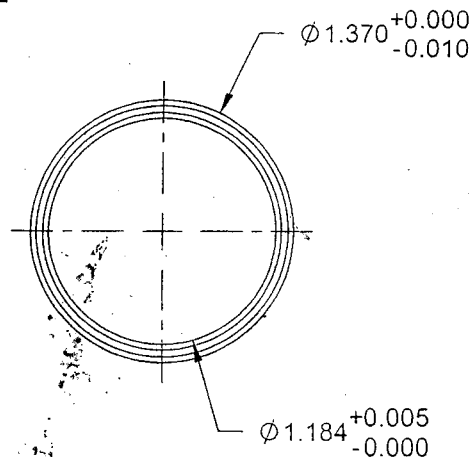
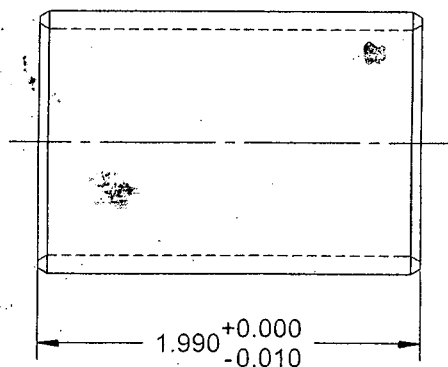
QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY		SCALE 1:1



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22679

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

$$0.175$$

$$1.05 \div 1.850$$

$$1.0175$$

$$1.185 = 1.150$$

$$1.472 - 1.419$$

$$1.053 = 1.770$$

$$1.472 = 1.424 = 0.24$$

$$1.856 = 1.111$$

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 14, 2005
08:26 am

Work Order No : 0022679
Project Name : D3233-5
Project For : WK512
Work Order Type : Main
Main WO Number :
House Part Number : D3233-5
Description : Hub Sleeve
Manufactured : No
Amount Req'd : 0
Amount Done : 0
Start Date : 03-11-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00